

5/8/6061



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3492-1

Job Sheet 213090



Part No: D3492-1

Job Qty: 100 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/16/20

Job Tracking No:

Due Date: 10/12/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	100 pcs	10/10/20	10/10/20	0.50	3.06	Hardinge - 1		<i>[Signature]</i> 20/09/23
120	QC 8	100 pcs	10/10/20	10/10/20	0.00	0.00	QC 8 - 12		<i>[Signature]</i> 20/09/23
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		



Container No: S302166



Part: D3492-1

Job No: 213090

Serial No/Batch: S302166

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/23/20

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CANADA
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				QC 8 - 82	
150	Handfinish - 1-1 Chemical-B4B	100 pcs	10/10/20	0.00 0.33	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
160	Powdercoat - 1 White, GI(A)-B4B <i>M 254409</i>	100 pcs	10/12/20	0.00 1.50	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
					Powdercoat - 5 - B4B
					Powdercoat - 6 - B4B
					Powdercoat - 7 - B4B
					Powdercoat - 8 - B4B
					Powdercoat - 9 - B4B
					Powdercoat - 10 - B4B
170	QC 3	100 pcs	10/12/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28

2020/09/24

20.9.29

START: 8:15.

N.T. 320°

FINISH: 8:45.

DAS 34 9:00

					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
180	Packaging 3-1 - Stock - B4B	100 pcs	10/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	FP-001 Jul 20-9-25
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	

DAS
40
SEP 2 9 2020

					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	100 pcs	10/12/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		68-6
				QC 21 - SA - 9	DAS	12
				QC 21 - SA - 77	21	SEP 29 2020
				QC 21 - SA - 28	9-88	

Part Op **100** - (Hardinge) 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: E
 Descriptions: **120** - (QC8- Inspect parts - second check)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only) START TIME: _____ FINISH TIME: _____
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	5.3000 ft (.053 ea)	100-Hardinge - 1	5299410

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.625	5	15	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches $\pm$ 0.005	0.065 0.055	.059	
2	Plug	0.060inches $\pm$ 0.005	0.065 0.055	.059	
3	Plug	0.394inches $\pm$ 0.010	0.404 0.384	.394	
4	Plug	0.625inches $\pm$ 0.010	0.635 0.615	.622	
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	.089	
6	Plug	0.500inches $\pm$ 0.010	0.510 0.490	.5	
7	Plug	0.050inches + 0.000 - 0.002	0.050 0.048	.049	
8	Plug	0.050inches $\pm$ 0.010	0.060 0.040	0.045 .045	
9	Plug	20.000Degrees $\pm$ 0.000	20.000 20.000	20	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					